

# Accessories

## Drive Rolls

- 132955 1/16 in. (1.6 mm)
- 132960 5/64 in. (2.0 mm)
- 132961 3/32 in. (2.4 mm)
- 132962 7/64 in. (2.8 mm)
- 132963 1/8 in. (3.2 mm)
- 193700 5/32 in. (4.0 mm)



**SubArc Parallel Cable**  
260775015  
15 ft. (4.6 m)



**SubArc Tandem Cable**  
260878015  
15 ft. (4.6 m)



**1200-Amp Twin-Wire Torch**  
301144 Long, 16.8 in. (427 mm)  
1,200 amps at 100 percent duty cycle.  
For 3/64–3/32 inch (1.2–2.4 mm) wires.

## Cables



- SubArc Control Cables**
- 260622030 30 ft. (9.1 m)
  - 260622050 50 ft. (15.2 m)
  - 260622060 60 ft. (18.3 m)
  - 260622080 80 ft. (24.4 m)
  - 260622100 100 ft. (30.5 m)
  - 260622120 120 ft. (36.6 m)
  - 260622200 200 ft. (61.0 m)

Cable between SubArc Interface or Motor Control and power source.



- Flux Hopper Extension Cables**
- 260623010 10 ft. (3 m)
  - 260623025 25 ft. (7.6 m)
  - 260623065 65 ft. (19.8 m)

Cable between SubArc Interface or Motor Control and flux hopper.



- Motor Extension Cables**
- 254232005 5 ft. (1.5 m)
  - 254232010 10 ft. (3 m)
  - 254232025 25 ft. (7.6 m)
  - 254232065 65 ft. (19.8 m)

Cable between SubArc Interface or Motor Control and drive motor.



- Continuum Motor/Control Cables**
- 263368015 15 ft. (4.6 m)
  - 263368020 20 ft. (6.1 m)
  - 263368025 25 ft. (7.6 m)
  - 263368050 50 ft. (15.2 m)
  - 263368080 80 ft. (24.4 m)
  - 263368100 100 ft. (30.5 m)

Cable between SubArc Motor Control and SubArc Remote Pendant.

## Submerged Arc Torches



**OBT 600 043923**  
600 amps at 100 percent duty cycle. For 1/16–5/32 inch (1.6–4.0 mm) wire. Torch has concentric flux flow nozzle.

### OBT 600 Torch Body Extensions

- 043967 1 in. (25.4 mm)
- 043969 2 in. (50.8 mm)
- 043973 4 in. (101.6 mm)
- 043975 6 in. (152.4 mm)



**OBT 1200 043900**  
1,200 amps at 100 percent duty cycle. For 1/16–5/32 inch (1.6–4.0 mm) wire. Torch has concentric flux flow nozzle and features a replaceable breakaway adapter end to prevent costly damage should torch run into an obstruction.

### OBT 1200 Torch Body Extension 043981

Overall length with extension is 9 inches (228.6 mm). Actual length of extension is 8.5 inches (215.9 mm).

### OBT Torch Contact Tips

OBT 600	OBT 1200	Wire Size
192700	192141	1/16 in. (1.6 mm)
192701	199026	5/64 in. (2.0 mm)
192702	192142	3/32 in. (2.4 mm)
192703	200771	7/64 in. (2.8 mm)
192704	192143	1/8 in. (3.2 mm)
192705	192144	5/32 in. (4.0 mm)

## Accessories (continued)



### Single-Wire Straightener

**199733**

For use with OBT 600 and OBT 1200 single-wire torches. For 1/16–5/32 inch (1.6–4.0 mm) wires.



### Twin-Wire Straightener

**301160**

Single adjustment for 1200-amp twin-wire torch only.



### SubArc Flux Hopper Digital Low Voltage

**300942**

25-pound-capacity flux hopper with automatic flux valve. The opening is sized to allow hook-up of any flux-hopper-mounted recovery system. Includes slag screen and 11-foot (3.3 m) power cable.



### Wire Reel

**108008**

For 60-pound (27 kg) coil of wire. Requires Spool Support Assembly (**119438**).

### Spool Support Assembly

**119438**

For 60-pound (27 kg) wire reel.



### Manual Slide

**301137**

Manual slide for smooth and accurate movement of the welding head. Slide allows for 7.87 inch (200 mm) travel adjustment with load capacity of 220 pounds (100 kg) at 1.64 feet (500 mm).

**Not recommended for tandem.**



### SubArc Single Mounting Bracket

**301134**

Single mounting bracket configures single-arc welding head to mount to manual slide.



### SubArc Tandem Mounting Bracket

**301135**

Tandem mounting bracket is a predesigned welding head configuration for tandem applications. Independent adjustments of lead and trail torches adapt to most applications.



### SubArc Mounting Hinge

**301136**

Mounting hinge allows welding head to swivel 90 degrees with minimal effort. Ideal for changing from longitudinal to circumferential welds.



### SubArc 3-Wheel Tractor Digital Package

**951755**

Package includes SubArc 3-Wheel Tractor, SubArc Tractor Interface Digital, SubArc Wire Drive 400, 10-pound (4.5 kg) capacity flux hopper with manual valve, 60-pound (27 kg) wire reel, OBT 600 torch and wire straightener. See literature AD/7.7 for more information.



### SubArc Portable Welding System

**951675** With SubArc DC 650 Digital

**951676** With SubArc DC 1000 Digital

**951677** With SubArc AC/DC Digital

SubArc Portable Welding System is a ready-to-weld submerged arc system for pressure vessel, pipe and welding that requires positioning equipment which can adapt to your application. See literature AD/7.6 for more information.

## Welding Intelligence™



### 14-pin Insight Core™ Module

**301072**

Insight Core is a simplified, internet-based industrial welding information management solution that monitors and reports welding activity for basic productivity and quality metrics. Requires Insight Core to SubArc Digital Series Adapter (**301295**). See Insight Core brochure (**266011**) for more information.



### Insight Core™ to

SubArc Digital

Series Adapter

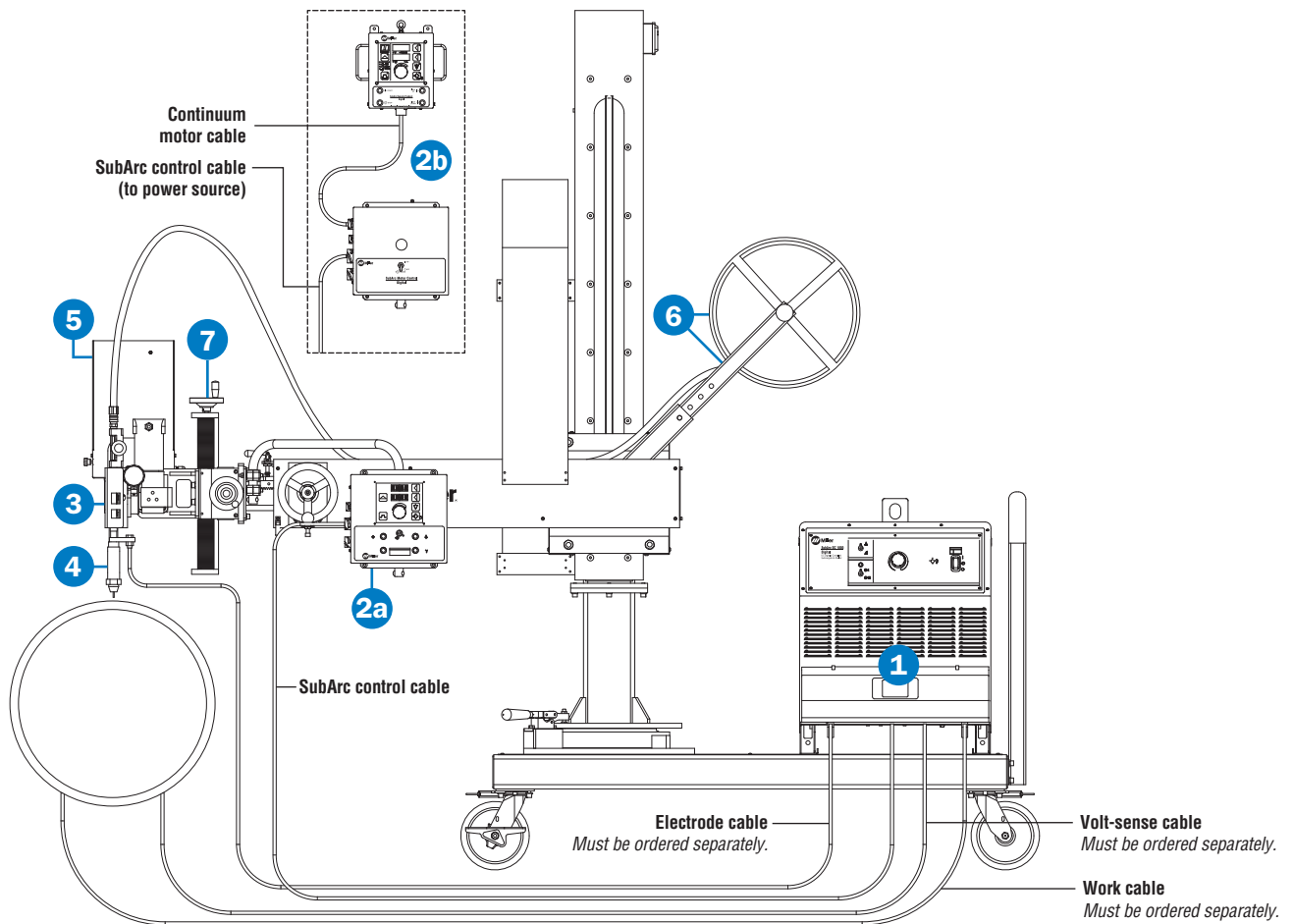
**301295**

### ArcAgent™ Auto

**301346**

See literature WI/1.0 for more information.

## Typical Installations (SubArc Interface and Remote Operator Interface Setups.)



### 1 Power Source

See page 12 for available models.

### 2 Interface (choose one)

- a **SubArc Interface Digital** — See page 12. Requires a SubArc control cable to connect power source to interface. See page 9 for available cable lengths.
- b **SubArc Remote Operator Interface** — See page 12. Consists of SubArc Motor Control Digital and SubArc Remote Pendant Digital. Requires a Continuum motor cable and a SubArc control cable. See page 9 for available cable lengths.

### 3 Drive Motor

See page 12 for available models. Includes 4-foot (1.2 m) motor control cable. See page 9 for optional cable extension lengths and required drive rolls.

### 4 Torch (choose one)

- a **Single-Wire** — See page 9 for single-wire torches, optional body extensions and required contact tips. See page 10 for optional wire straightener.
- b **Twin-Wire** — See page 9 for twin-wire torch and required contact tips. See page 10 for optional wire straightener.

### 5 Flux Hopper

See page 10. Includes 11-foot (3.3 m) flux hopper cable. See page 9 for optional cable extension lengths.

### 6 Reel/Spool Assembly

See page 10. Wire reel requires spool support assembly.

### 7 Manual Slide

See page 10.

# Ordering Information

Equipment and Options	Stock No.	Description	Qty.	Price
<b>1 Power Source</b>				
SubArc DC 650 Digital	<b>907622</b>	230/460/575 V, 60 Hz		
SubArc DC 800 Digital (50 Hz) <b>CE</b>	<b>907623</b>	380/400/440 V, 50 Hz		
SubArc DC 1000 Digital	<b>907624</b>	230/460/575 V, 60 Hz		
SubArc DC 1250 Digital (50 Hz) <b>CE</b>	<b>907625</b>	380/400/440 V, 50 Hz		
SubArc AC/DC Digital	<b>907620</b>	460 V, 60 Hz		
SubArc AC/DC 1250 Digital (50 Hz) <b>CE</b>	<b>907621</b>	380/400 V, 50 Hz		
<b>2a Interface Controls and Cables</b>				
SubArc Interface Digital	<b>300936</b>	CV, AC/DC digital control		
SubArc Control Cables		See page 9		
<b>2b</b>				
SubArc Motor Control Digital	<b>301425</b>	Motor control for Remote Pendant Digital		
SubArc Remote Pendant Digital	<b>301424</b>	CV, AC/DC digital control, requires <b>301425</b> and Continuum motor/control cable		
Continuum Motor/Control Cables		See page 9		
SubArc Control Cables		See page 9		
<b>3 Drive Motors, Extension Cables and Rolls</b>				
SubArc Wire Drive 400 Digital Low Voltage	<b>300938</b>	Standard-speed right-angle drive assembly		
Motor Extension Cables (if needed)		See page 9		
Drive Rolls		See page 9		
<b>4a Single-Wire Torches, Straightener and Tips</b>				
OBT 600	<b>043923</b>	600 amps, 100% duty cycle, air cooled		
OBT 1200	<b>043900</b>	1,200 amps, 100% duty cycle, air cooled		
OBT Torch Body Extensions (if needed)		See page 9		
Single-Wire Straightener	<b>199733</b>	For single-wire torches		
Contact Tips		See page 9		
<b>4b Twin-Wire Torch, Straightener and Tips</b>				
1200-Amp Twin-Wire Torch	<b>301144</b>	Long, 16.8 in. (427 mm), 1,200 amps, 100% duty cycle		
Twin-Wire Straightener	<b>301160</b>	Single adjustment for twin-wire torch only		
Contact Tips		See page 9		
<b>5 Flux Hopper and Cables</b>				
SubArc Flux Hopper Digital Low Voltage	<b>300942</b>	25 lb. (11 kg) flux capacity		
Flux Hopper Extension Cables (if needed)		See page 9		
<b>6 Reel/Spool Assembly</b>				
Wire Reel	<b>108008</b>	For 60 lb. (27 kg) coil, requires <b>119438</b>		
Spool Support Assembly	<b>119438</b>			
<b>7 Slide</b>				
Single Manual Slide	<b>301137</b>	7.87 in. (200 mm) travel adjustment		
<b>Accessories</b>				
SubArc Digital Converter		See page 8		
SubArc Parallel/Tandem Cables		See page 9		
SubArc Brackets/Hinge		See page 10		
SubArc 3-Wheel Tractor/Portable Welding System		See page 10		
Welding Intelligence™		See page 10		

Date:

Total Quoted Price:

Distributed by:

